

Work Order ID 82234

Monday, June 04, 2012 1:41:26 PM

82234

Page 1

Item ID: D3023-1

Accept

N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Back Panel

Start Date: 3/27/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 4/10/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: *NKF*Date: *12-06-04* Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3023

Rev A

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3023

Dwg Rev: *A*Prog Rev: *A*

***graind direction along 28.100" ***

2-Deburr if necessary

*B12-5-6**(4)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-5-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Insp.
Qty Qty Number Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location: *up*

0.00

180

Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

11/2-06-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, June 04, 2012 1:41:25 PM

Page 1

Work Order ID: 82234
Parent Item: D3023-1
Parent Item Name: Back Panel

Start Date: 3/27/2012
Start Qty: 4.00
Required Date: 4/10/2012
Required Qty: 4.00

Comments: IPP C02.01.23Revised NG
IPP Rev:D 08-04-16 now water jet DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.032 2024-T3 .032 sheet		Purchased	No			100	sf	188.2481	2.8777	12.116632			

IB 12-5-6

Location

MAT022

118243

118523

121309

Loc Qty

188.2481

16.2481

73

99

Loc Code

121309

4

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

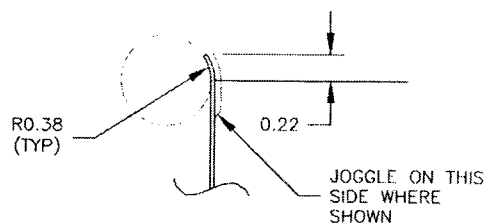
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

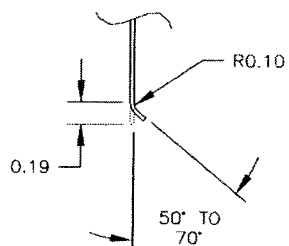
NOTE: Date & initial all entries



SECTION A-A
SCALE 1:1
(TYPICAL, EXCEPT WHERE SHOWN)

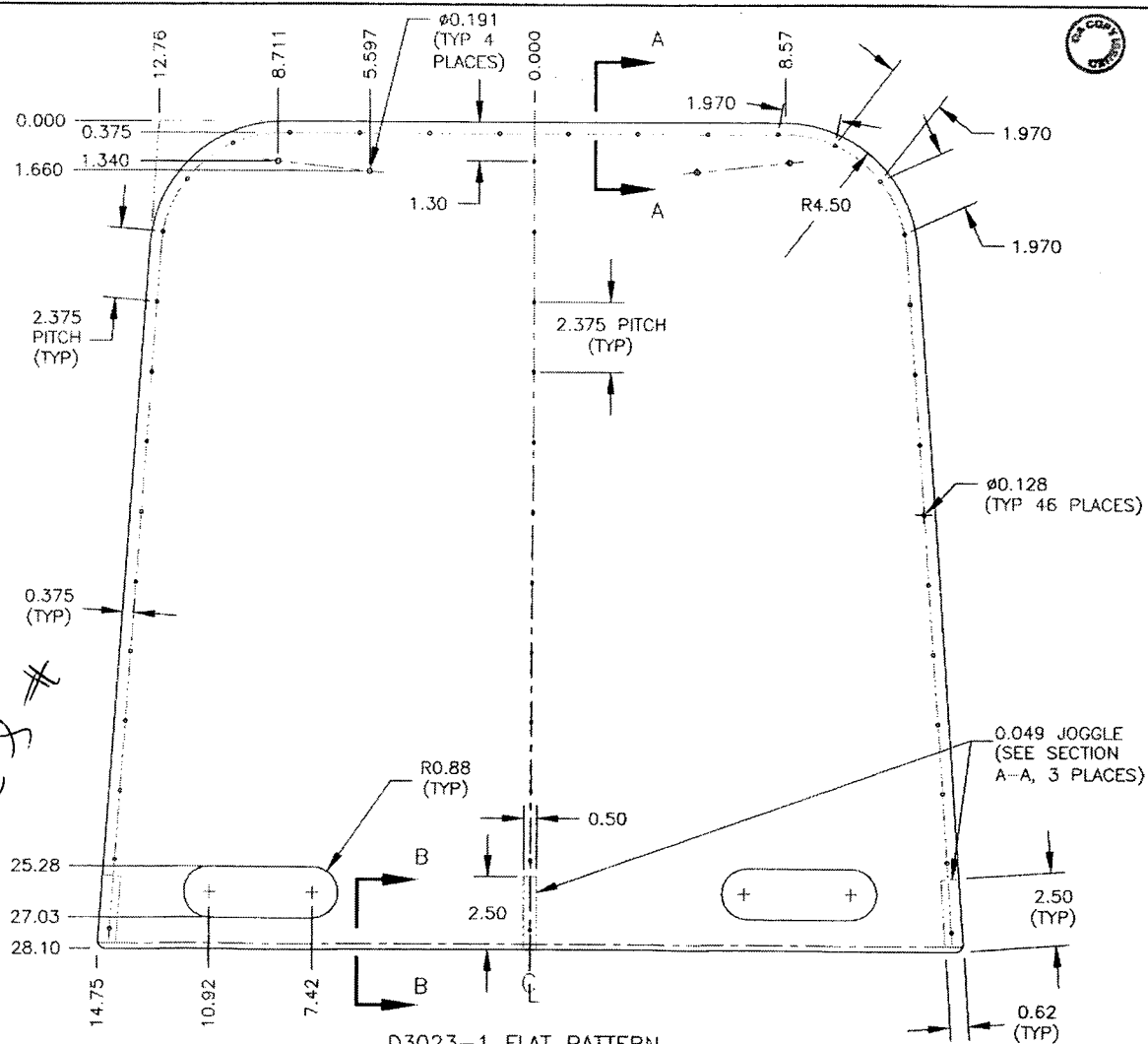


SECTION B-B
SCALE 1:1
(BOTTOM EDGE ONLY)



RELEASED
9.06.07

D3023-1 BEND DETAIL



D3023-1 FLAT PATTERN

D3023-1 BACK PANEL:

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES.
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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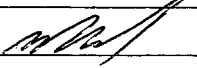
A	01.05.18	NEW ISSUE
DESIGN	DRAWN BY	DART DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3023
DATE	TITLE	REV. A SHEET 1 OF 1 SCALE
01.05.18	BACK PANEL	1:4

DART AEROSPACE LTD		Work Order:	82234
Description: Back Panel		Part Number:	D3023-1
Inspection Dwg: D3023 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.128	+0.005/-0.001	.132	✓		V RBJZ	
Ø0.191	+0.005/-0.001	.193	✓		V	
1.660	+/-0.010	1.661	✓		V	
0.375	+/-0.010	.377	✓		V	
1.340	+/-0.010	1.343	✓		V	
2.375	+/-0.010	2.376	✓		V	
0.375	+/-0.010	.377	✓		V	
25.28	+/-0.030	25.28	✓		T RB01	
27.03	+/-0.030	27.03	✓		T	
28.10	+/-0.030	28.10	✓		T	
1.30	+/-0.030	1.32	✓		V	
2.375	+/-0.010	2.377	✓		V	
8.711	+/-0.010	8.711	✓		V	
5.597	+/-0.010	5.597	✓		V	
8.57	+/-0.030	8.57	✓		T	
1.970	+/-0.010	1.971	✓		V	
7.42	+/-0.030	7.424	✓		V	
10.92	+/-0.030	10.92	✓		T	
14.75	+/-0.030	14.77	✓		T	

Measured by:	RB	Audited by:		Prototype Approval:	N/A
Date:	12-5-06	Date:	12.05.07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.11.27	New Issue	KJ/EC 